

Date:  
User:Tuesday, 10/06/2008 10:03:09 AM  
Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SKIDTUBE ASSEMBLY
<b>Job Number</b>	: 39749		
<b>Estimate Number</b>	: 10022		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D205634011
<b>This Issue</b>	: 10/06/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: N/A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 39517	<b>Drawing Revision</b>	: N/A
	<b>Type</b> : SKIDTUBES	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 20/06/2008
<b>Checked &amp; Approved By</b>	: <u>JLD 08.6.10</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL

JLD  
08.6.11

Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D205-634-011 CHG005

S 08/06/24

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

39749A

SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

1 x D205-634-041 Batch 39749A

50

4.0

K10003

Saddle, D205-634-011



(A)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 K10003 Saddle Kit 38907

8/6/24

SCD

5.0

QC4

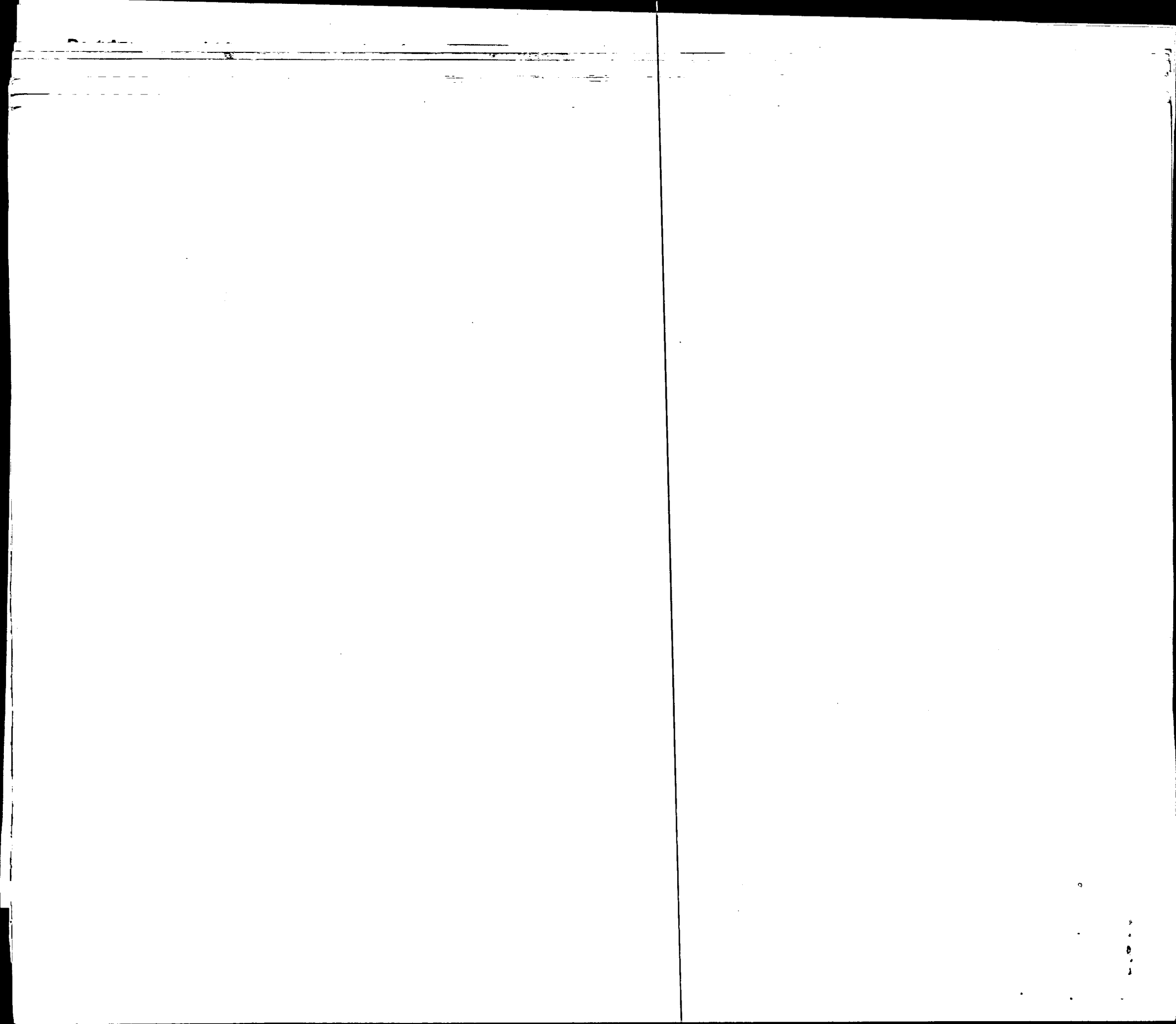
INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/06/24 @

339749A



NO. 158

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay E.  
Job number: 839517 A  
Part number: D205634041  
Description: SKID tube  
Welding Process: Tig[ ☒ ] Mig[ ☐ ]  
Base material: Alum.  
Current: AC[ ☒ ] DC[ ☐ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[ ☒ ] fail[ ☐ ]  
Penetration: pass[ ☒ ] fail[ ☐ ]

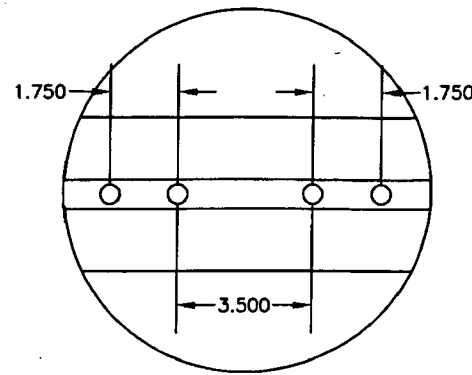
UNACCEPTABLE

Cracks: pass[ ☒ ] fail[ ☐ ]  
Undercut: pass[ ☒ ] fail[ ☐ ]  
Pin holes: pass[ ☒ ] fail[ ☐ ]  
Overlap (cold lap): pass[ ☒ ] fail[ ☐ ]  
Porosity (surface): pass[ ☒ ] fail[ ☐ ]  
Coloration: pass[ ☒ ] fail[ ☐ ]

Qualifier David Dugal Date of Test Coupon 08/06/02  
Welder Barclay Elliott Date of Test Coupon 08/06/02

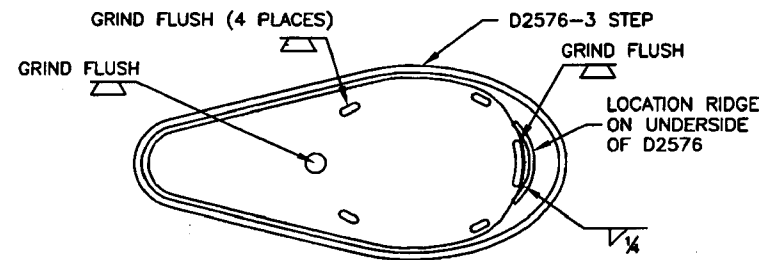
The above named individual is qualified in accordance with AWS D17.1.2001 to weld

**DETAIL A**  
SCALE 5:24

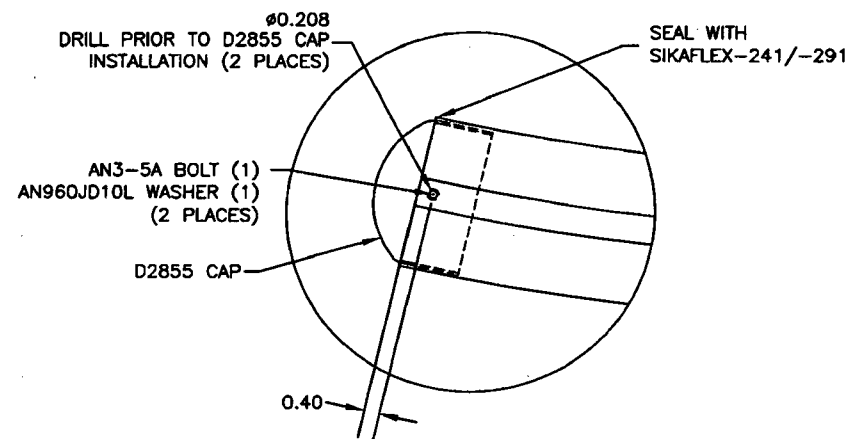


**RELEASED**  
07-06-28

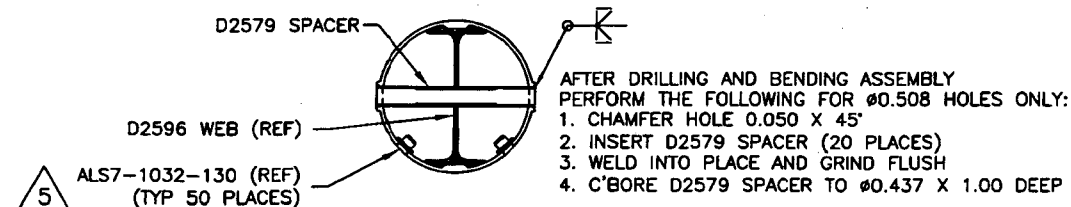
**DETAIL B**  
SCALE 5:24



**DETAIL C**  
SCALE 5:24



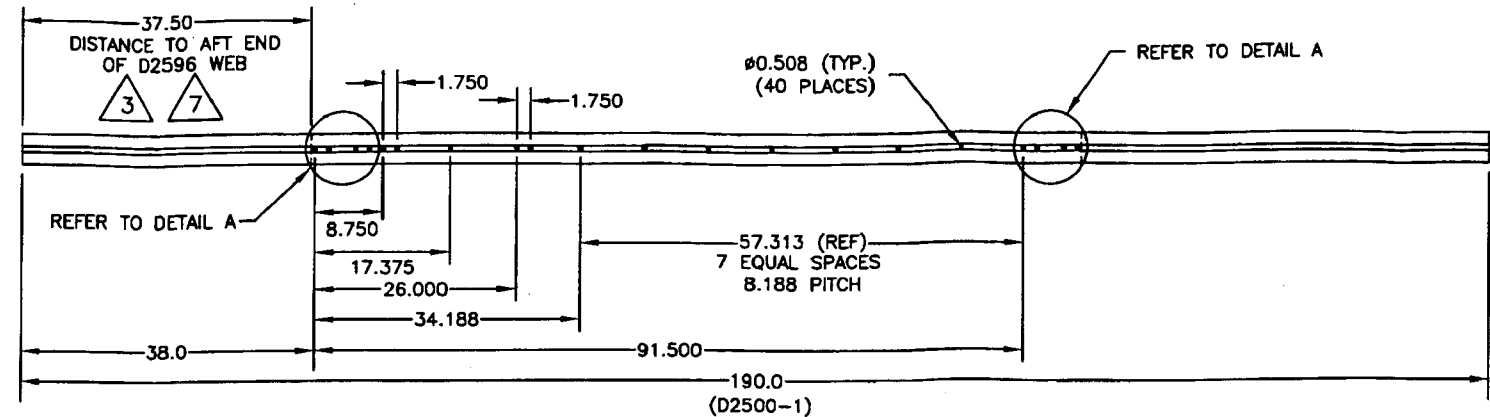
**SECTION D-D**  
SCALE 5:24



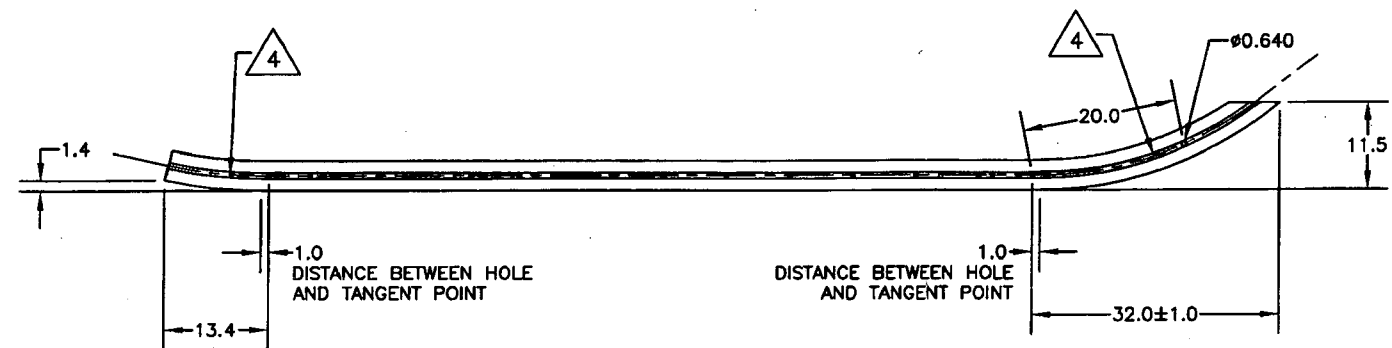
**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

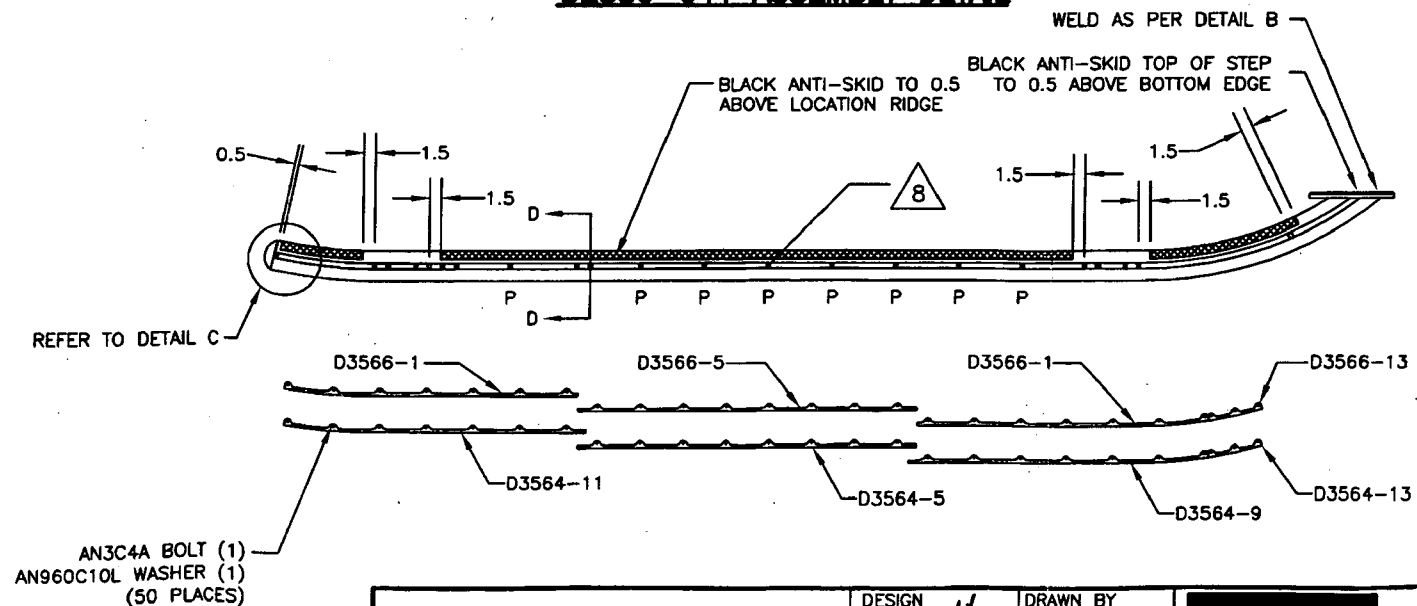
**D2580-1 DRILLING DETAIL**



**D2580-1 BENDING AND CUTTING DETAIL**



**D2580-041 ASSEMBLY DETAIL**



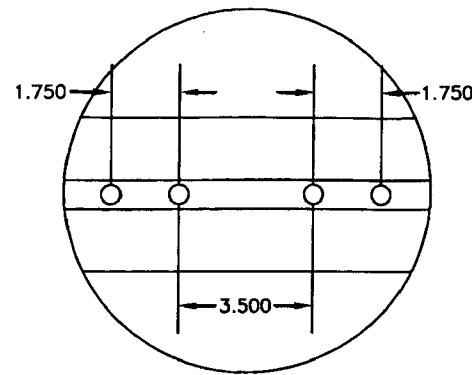
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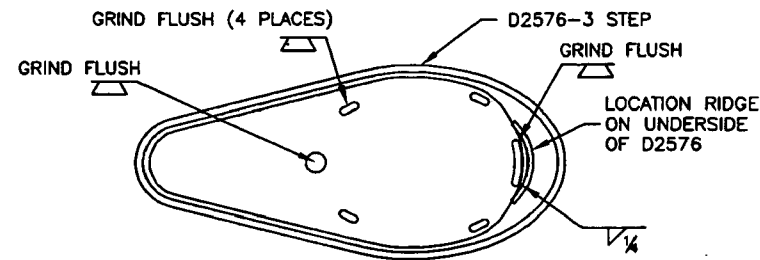
DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 2 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

**DETAIL E**  
SCALE 5:24

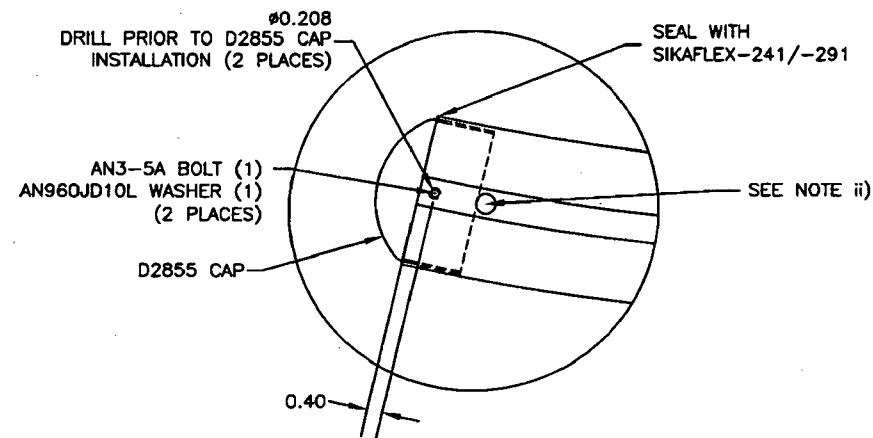


**RELEASED**  
07.02.27

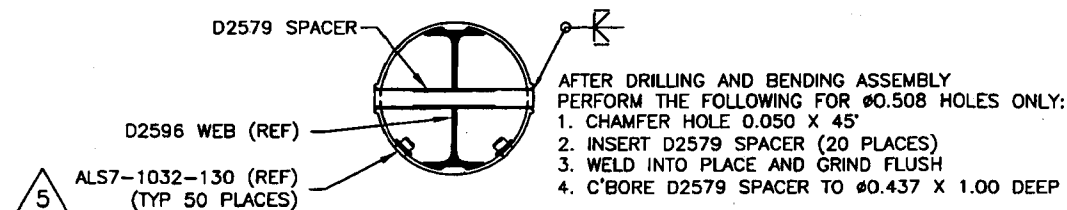
**DETAIL F**  
SCALE 5:24



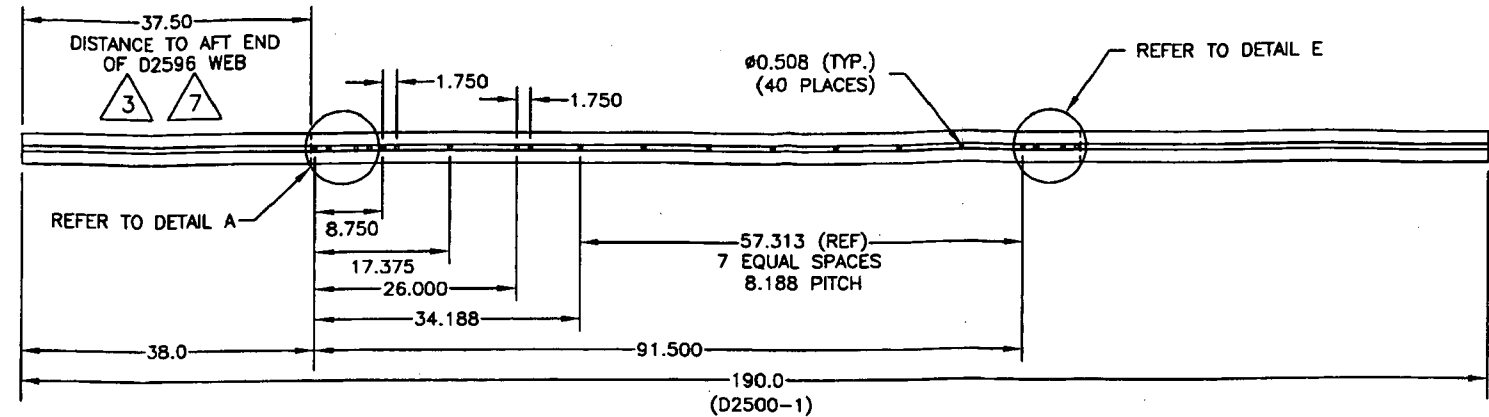
**DETAIL G**  
SCALE 5:24



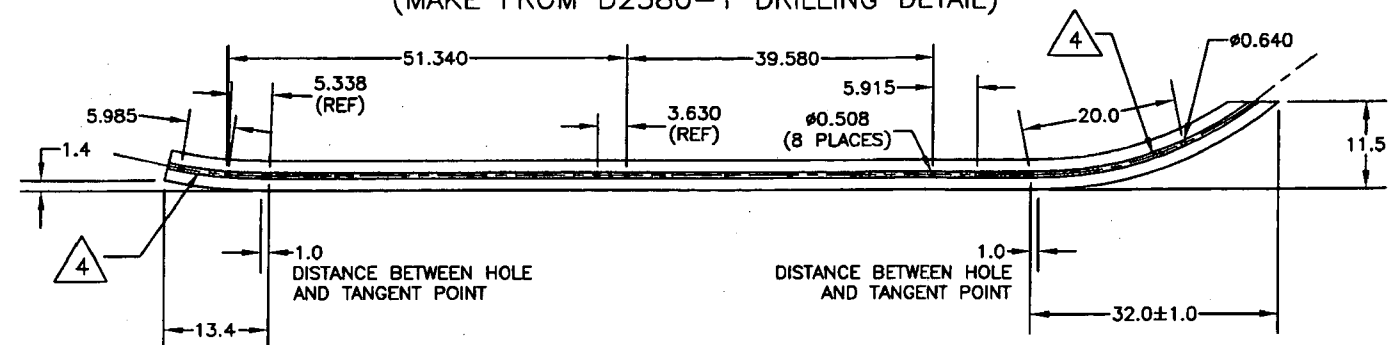
**SECTION H-H**  
SCALE 5:24



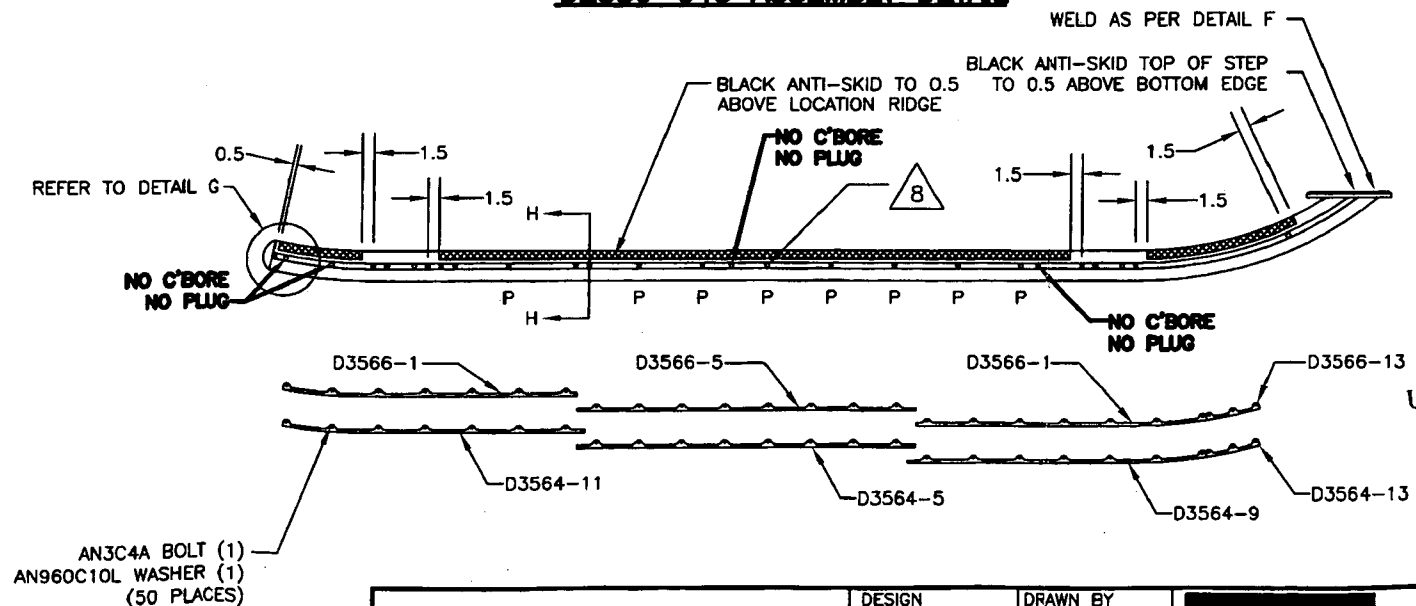
**D2580-1 DRILLING DETAIL**



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



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**D2580-045 NOTES**

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

